



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3065-5
Job Sheet 202130



Part No: D3065-5

Part Name: Step Leg



Part Weight: 0 lbs

Job Created: 10/18/19

Due Date: 11/5/19

Type: Stock

Job Qty: 320 pcs

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
122	Purchasing	320 pcs		11/5/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
123	Packaging 2-1 - Receive - B4B	320 pcs		11/5/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Container No: S245331



Part: D3065-5

Job No: 202130

Serial No/Batch: S245331

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/07/20

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
124 QC 6	320 pcs	11/5/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	JAN 28 2020 40
				QC 6 - 81	9-89
125 Waterjet - Flow - B4B	320 pcs	11/5/19	0.00 5.33	Waterjet - Flow - B4B	20/01/29
130 Handfinish - 1-1 Chemical-B4B	320 pcs	11/5/19	0.00 7.24	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	FEB 05 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	

					Handfinish - 1 - 13 - B4B					
					Handfinish - 1 - 14 - B4B					
					Handfinish - 1 - 15 - B4B					
					Handfinish - 1 - 16 - B4B					
					Handfinish - 1 - 17 - B4B					
					Handfinish - 1 - 18 - B4B					
					Handfinish - 1 - 19 - B4B					
					Handfinish - 1 - 20 - B4B					
					Handfinish - 1 - 21 - B4B					
					Handfinish - 1 - 22 - B4B					
					140 QC 7	320 pcs	11/5/19	0.00 0.00	QC 7 - 10	
									QC 7 - 13	
									QC 7 - 14	
QC 7 - 15										
QC 7 - 17										
QC 7 - 18										
QC 7 - 19										
QC 7 - 2										
QC 7 - 28										
QC 7 - 3										
QC 7 - 30	DAS 30 388 FEB 12 2020									
QC 7 - 34										
QC 7 - 36										
QC 7 - 37										
QC 7 - 41										
QC 7 - 47										
QC 7 - 48										
QC 7 - 51										
QC 7 - 58										
QC 7 - 59										
QC 7 - 60										
QC 7 - 9										
QC 7 - 68										
QC 7 - 50										
QC 7 - 67										
QC 7 - 40										
QC 7 - 24										
QC 7 - 43										
QC 7 - 61										
QC 7 - 81										
QC 7 - 76										
QC 7 - 79										
150 Packaging 3-1 - Stock - B4B	320 pcs	11/5/19	0.00 0.00	Packaging 3 - 1 - B4B						
				Packaging 3 - 2 - B4B						
				Packaging 3 - 3 - B4B						
				Packaging 3 - 4 - B4B						
				Packaging 3 - 5 - B4B						
				Packaging 3 - 6 - B4B						
				Packaging 3 - 7 - B4B						
				Packaging 3 - 8 - B4B	DAS 30 388 FEB 12 2020					
				Packaging 3 - 9 - B4B						
					Plex 10/22/19 10:09 AM dart.lacelle.linda					

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	320 pcs	11/5/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-28 FEB 12 2020
Part Op 122 - ISSUE P/O: 44866 MANUFACTURE D3065-5 AS PER DWG *****IMPORTANT, VERIFY GRAIN					
Descriptions: DIRECTION AS PER DWG***** C OF C IS REQUIRED					
125 - *****CHECK GRAIN DIRECTION***** DEBURR ON DEBURRING MACHINE (no set-up time required)					
130 - Chemical Conversion Coat per QSI005 4.1					
140 - QC7-Inspect Chemical Conversion Coat					
150 - Identify as per dwg & Stock Location: _____ - LOCATION : GA 127F					
160 - QC21- Final Inspection - Work Order Release					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3065-5P	Step Leg	320 Ea (1 ea)	122-Purchasing	S245330
M6061T6S.080	6061-T6 .080 Sheet	264 sf (.825 ea) 288 sf	122-Purchasing	S227114

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
122-Purchasing	D3065-5P	320	0	0
	M6061T6S.080 4x6	264 288 sf on order	77	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches ± 0.010	16.468 16.448		
2	Step Log	15.750inches ± 0.005	15.755 15.745		
3	Step Log	2.250inches ± 0.005	2.255 2.245		
4	Step Log	3.460inches ± 0.005	3.465 3.455		
5	Step Log	0.865inches ± 0.005	0.870 0.860		
6	Step Log	6.020inches ± 0.005	6.025 6.015		
7	Step Log	1.205inches ± 0.005	1.210 1.200		
8	Step Log	3.484inches ± 0.005	3.489 3.479		
9	Step Log	0.871inches ± 0.005	0.876 0.866		
10	Step Log	8.325inches ± 0.010	8.335 8.315		
11	Step Log	0.551inches ± 0.010	0.561 0.541		
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213		
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128		

Plex 10/22/19 10:09 AM dart.lacelle.linda



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044866



Supplier: BIL003-VC
Billet Precision
2730 Fenton Road
Gloucester
ON
K1T 3T7 Canada
Phone: 6138221040

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044866
PO Date: 10/23/19
Due Date: 12/20/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202130	D3065-5P	D3065 REV.B			Step Leg - manufacture as per drawing D3065-5 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	1/6/20	166 Ea	0 Ea	166 Ea	\$11.47/Ea	\$1,904.02
Line Item Note: PRIORITY #1 X1666 JAN 07 2020 DP DAS 40 9-89														
2	202104	D3065-7P	D3065 REV.B			Step Spacer - manufacture as per Dwg D3065-7 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	1/6/20	31 Ea	0 Ea	31 Ea	\$7.50/Ea	\$232.50
Line Item Note: PRIORITY #3														
3	202128	D3065-1P	D3065 REV.B			Step Spacer - manufacture as per dwg D3065-1 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	1/6/20	76 Ea	0 Ea	76 Ea	\$6.00/Ea	\$456.00
Line Item Note: PRIORITY #1														
4	202129	D3065-3P	D3065 REV.B			Step Spacer - manufacture as per dwg D3065-3 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	12/20/19	119 Ea	0 Ea	119 Ea	\$8.00/Ea	\$952.00
Line Item Note: PRIORITY #2														

Plex 1/7/20 12:51 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044866



Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	203665	D3065-1P	D3065 REV.B			Step Spacer : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$6.00/Ea	\$0.00
6	203662	D3065-5P	D3065 REV.B			Step Leg : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$11.47/Ea	\$0.00
7	203663	D3065-7P	D3065 REV.B			Step Spacer : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$7.50/Ea	\$0.00
8	203664	D3065-3P	D3065 REV.B			Step Spacer : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$8.00/Ea	\$0.00
9	204367	D3065-5P	D3065 REV.B			Step Leg : Various STC's	Received	-	12/10/19	80 Ea	80 Ea	0 Ea	\$11.47/Ea	\$0.00
10	204369	D3065-7P	D3065 REV.B			Step Spacer : Various STC's	Received	-	12/10/19	40 Ea	40 Ea	0 Ea	\$7.50/Ea	\$0.00
11	204370	D3065-1P	D3065 REV.B			Step Spacer : Various STC's	Received	-	12/10/19	40 Ea	40 Ea	0 Ea	\$6.00/Ea	\$0.00
12	204371	D3065-3P	D3065 REV.B			Step Spacer : Various STC's	Received	-	12/10/19	40 Ea	40 Ea	0 Ea	\$8.00/Ea	\$0.00
13	204891	D3065-5P	D3065 REV.B			Step Leg : Various STC's	Received	-	12/24/19	63 Ea	63 Ea	0 Ea	\$11.47/Ea	\$0.00
14	204892	D3065-7P	D3065 REV.B			Step Spacer : Various STC's	Received	-	12/24/19	88 Ea	88 Ea	0 Ea	\$7.50/Ea	\$0.00
15	204893	D3065-1P	D3065 REV.B			Step Spacer : Various STC's	Received	-	12/24/19	43 Ea	43 Ea	0 Ea	\$6.00/Ea	\$0.00

Grand Total: \$3,544.52

Order Notes

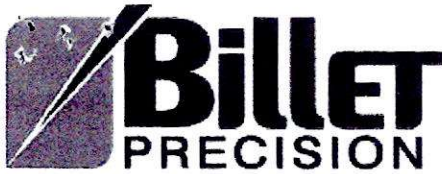
Procurement Quality Clauses
A000 RIGHT OF ENTRY
A001 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/7/20 12:51 PM Dart.Guerin.Kimberley

**BILLET PRECISION LTD.**

2730 Fenton Road
Gloucester, ON K1T 3T7
Phone: 613-822-1040
Fax:

Packing List**Bill** DART AEROSPACE LTD.

To: 1270 ABERDEEN STREET
Hawkesbury, ON K6A 1K7
Canada

Ship DART AEROSPACE LTD.

To: 1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Shipment No: 19428
Shipment Date: 01/03/20
Ship Via: Prepaid and Charge (Best Way)
Order Number: 18162
Order Date: 10/25/19

Customer Code: DART
Phone: (613) 632-5200
PO Number: POHB044866
Terms: Net 30 Days

<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>Quantity</u>	<u>Back Ord</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	176	166		10		EA	D3065-5 STEP LEG ASSEMBLY		18162-01

In keeping with our ISO 9001:2015 / AS9100 Rev D commitment, the product listed hereon has been manufactured from and in accordance with the specified requirements of the referenced purchase order. This is to certify that the above parts are RoHS compliant and have been processed in accordance with the terms of your purchase order and conform fully to the specifications quoted.

THE LIABILITY OF BILLET PRECISION LTD. WITH RESPECT TO THE SERVICES CHARGED FOR HEREIN SHALL IN NO EVENT EXCEED THE AMOUNT OF THE INVOICE. ALL CLAIMS OF SHORTAGE/ REJECTS MUST BE MADE WITHIN 10 DAYS FROM DELIVERY DATE.

UNAUTHORIZED RETURNS WILL NOT BE ACCEPTED AND RETURNED AT YOUR EXPENSE. AN RMA# MUST APPEAR ON ALL RETURNS ALONG WITH A COPY OF THE PAPERWORK.

RECEIVED

JAN 07 2020

DART AEROSPACE LTD.

PR
Packing Clerk's Initials
BILLET PRECISION LTD.

Received In Good Order By
DART AEROSPACE LTD.

**BILLET PRECISION LTD.**

2730 Fenton Road
Gloucester, ON K1T 3T7
Phone: 613-822-1040
Fax:

Certificate of Conformance

To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

From: BILLET PRECISION LTD.
2730 Fenton Road
Gloucester, ON K1T 3T7
Canada

Packing List No: 19428
Shipping Date: 01/03/20

Today's Date: 01/07/20
PO Number: POHB044866

<u>Quantity</u>	<u>Shipped</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
166		EA	D3065-5 STEP LEG ASSEMBLY		18162-01

DAS
40
9-89

In keeping with our ISO 9001:2015 / AS9100 Rev D commitment, the product listed hereon has been manufactured from and in accordance with the specified requirements of the referenced purchase order. This is to certify that the above parts are RoHS compliant and have been processed in accordance with the terms of your purchase order and conform fully to the specifications quoted.

THE LIABILITY OF BILLET PRECISION LTD. WITH RESPECT TO THE SERVICES CHARGED FOR HEREIN SHALL IN NO EVENT EXCEED THE AMOUNT OF THE INVOICE. ALL CLAIMS OF SHORTAGE/ REJECTS MUST BE MADE WITHIN 10 DAYS FROM DELIVERY DATE.

UNAUTHORIZED RETURNS WILL NOT BE ACCEPTED AND RETURNED AT YOUR EXPENSE. AN RMA# MUST APPEAR ON ALL RETURNS ALONG WITH A COPY OF THE PAPERWORK.

RECEIVED

JAN 07 2020

DART AEROSPACE LTD.

FB

Inspector's Initials
BILLET PRECISION LTD.


Authorized Signature
BILLET PRECISION LTD.

DART AEROSPACE LTD		Work Order:	POH3044866
Description: Step Leg		Part Number:	D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒	First Article	☐	Prototype
-------------------------------------	---------------	--------------------------	-----------

[illegible]

DAS
40

Measured by:	40 9-89	Audited by:	PD	Prototype Approval:	N/A
Date:	NOV 21 2019	Date:	19-11-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	



F.A.I. Report

Customer: DART
 Part No: D3065-5
 Dwg Rev: B
 Description: Step Leg
 Job No: 18162-01
 Date: November 20, 2019

Note	No.	Imperial				FIRST OFF						Method of Inspection	Tool I.D	Sample Frequency
		Nominal	+/- Tol	Upper	Lower									
	1	1.640	±0.010	1.650	1.630	1.634						Optical Comparator	PP-001	
	2.1	3.460	±0.010	3.470	3.450	3.457						Caliper	VER-051	
	2.2	(.866 PITCH)				0.863						Caliper	VER-051	
	3	0.551	±0.010	0.561	0.541	0.553						Caliper	VER-051	
	4	0.213	±0.010	0.223	0.203	0.211						Caliper	VER-051	
	5.1	6.020	±0.010	6.030	6.010	6.02						Caliper	VER-051	
	5.2	(1.205 PITCH)				1.204						Caliper	VER-051	
	6	2.770	±0.010	2.780	2.760	2.77						Optical Comparator	PP-001	
	7	0.741	±0.010	0.751	0.731	0.743						Optical Comparator	PP-001	
	8	3.484	±0.010	3.494	3.474	3.483						Caliper	VER-051	
	9	8.325	±0.010	8.335	8.315	8.33						Height Gauge	HT-003	
	10	16.458	±0.010	16.468	16.448	16.462						Caliper	VER-154	
	11	Ø0.128	+0.005/-0.001	0.133	0.127	0.128						Pin Gauge	Set 1	
	12	15.750	±0.010	15.760	15.740	15.748						Caliper	VER-154	
	13	5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED										✓	N/A	
	14	6) ALL DIMENSIONS ARE IN INCHES										✓	N/A	
	15	4) BREAK ALL SHARP EDGES 0.005 TO 0.010										Visual	N/A	
	16	3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1										N/A	N/A	
	17	2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4026 OR AMS 4027) 0.080" THICK										Customer Supplied	N/A	
	18	1) MACHINE PER DWG FILE "D3065-5.SLDPRPT"										✓	N/A	
	19	2. Surface roughness 125										Visual	N/A	
	20	3. Remove sharp edges .015 max.										Visual	N/A	
	21	4. Threads per MIL-S-7742										N/A	N/A	
	22	5. Holes per the following table - See page two										✓	N/A	
	23	7. Angles +/- 1/2°										Formtracer	FT-001	
	24	8. Parallelism +/- 0.0025										N/A	N/A	
	25	9. Eccentricity 0.005 Max										N/A	N/A	
	26	10. Symmetry about all M/C center lines 0.005										N/A	N/A	

*** INSPECT AND RECORD EVERY 20th PART 100%, INCLUDING FIRST OFF AND SHIFT CHANGE ***

1			THIS FEATURE IS TO BE INSPECTED 100%. RECORD EVERY ___th PART.			FINAL INSPECTION PURPOSE ONLY			BY:		
2						QTY INSPECTED:1			BILLET 2		
3						FINAL INSPECTION DATE: 11/20/2019					